

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017058**Date Inspected:** 28-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Liu Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10

BAY 10, BIKE PATH (HSR1(B)-9343)

During random in process inspection this QA inspector observed that ZPMC personnel performing heat straightening on the weld joints of bike path. The CWI monitoring HSR is identified Mr. Qiu Wen. The members are identified as OBG components and the weld designations reviewed are as follows.

BK004A1-030-009

**TOWER FACADE SUBASSEMBLY**

SMAW welding of weld joint 011 located on SD1-SFSA4-328.

Welders are identified as 056200 and 056364. ZPMC CWI is identified as Mr. Zhang Huang.

The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

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### OBG BIKE PATH BK004A-032

During random in process inspection this QA inspector observed that ZPMC personnel performing fit up of the stringer plate to deck plate of above mentioned bike path. The welders are identified as 061398 and 054547. ZPMC QC is identified as Mr. Yuan Hui Gang. The welding variables recorded by QC appeared to comply with WPS-B-P-2112. The members are identified as OBG components.

### BAY 11

#### BIKE PATH STRINGER PLATE

During random in process inspection this QA inspector observed that ZPMC NDT personnel performing Magnetic Particle Testing (MT) on the weld joint of stringer plate of bike path BK004A-022. The members are identified as OBG components.

### WEST TOWER LIFT 5(T-WR3650)

SMAW welding of weld joint 004A/B(Repair) located on WSD1-TL5-4F-F.

Welder is identified as 037996. ZPMC QC is identified as Mr. Zhao Mao Mao.

The welding variables recorded by QC appeared to comply with WPS-385-SMAW-3G(3F)-REPAIR.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gaikwad,Umesh

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer